

Date: Monday, 05/05/2008 10:54:55 AM  
 ser: Jean-Luc Menard

## Process Sheet

D1R

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS  
 Job Number : 39030  
 Estimate Number : 13301  
 P.O. Number :  
 This Issue : 05/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : MACHINED PARTS  
 Previous Run :  
 Written By : Job. 05.05.  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 08-05-05 JLM Verified By:EC

Part Number : D37651  
 Drawing Number : D3765 PROTO  
 Project Number : N/A  
 Drawing Revision : PROTO 08.05.29 (revised)  
 Material :  
 Due Date : 12/05/2008 Qty: 14 Um: Each

## Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6R1000

ROUND BAR 1.00"



Comment: Qty.: 0.1969 f(s)/Unit Total : 2.7563 f(s)

ROUND BAR 1.00"

Batch: M104554

RD 08/05/08

2.0

DOOSAN LATHE

DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA744 Rev: proto. & Dwg D3765 Rev: proto.

2-Deburr per dwg D3765

RD 08/05/08

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 08/05/08

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-SLIT PART USING 4" -7/32" WITH .063" RAD SLITTING SAW

2-DEBURR

RD 08/05/08

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 39030

Part Number: D37651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Handwritten: 08/20 08/25/08*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Handwritten: 080529 08/05/09 (24)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten: 08-05-20 (214)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

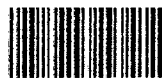
**ENGINEERING  
APPROVAL**

*Handwritten: 080520*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten: X N/A Eng lab 08-05-29*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 08.05.29 Promtype*

Job Completion



*Handwritten: 08-06-11*

8

7

6

5

4

3

2

1

D

C

B

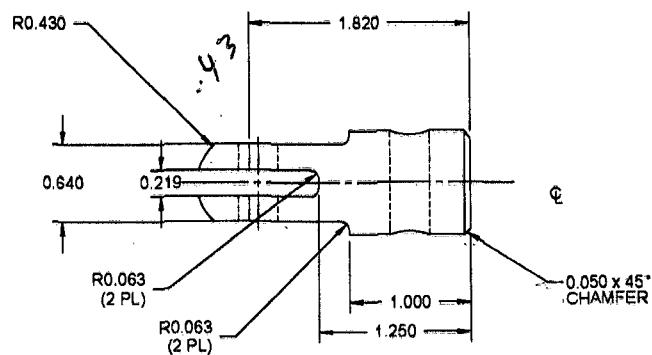
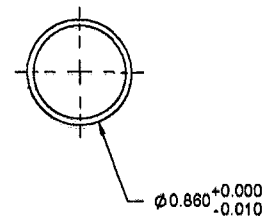
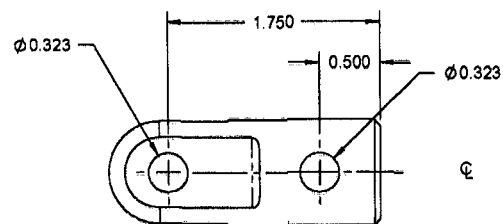
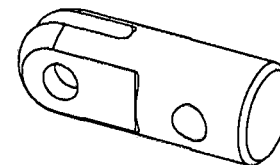
A

D

C

B

A



### D3765-1 CLEVIS

PROTOTYPE  
RD 08.05.29  
REVIEWED

#### NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM ROD (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3765	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLEVIS	1:1
DATE	08.05.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

Date: 07/05/25  
Supplier: Metanx solution

Batch No: 1104554  
Dart P/O: 3809

Packing Slip:  
Invoice:  
Receipt:

Yes ☒ No ☐  
Yes ☐ No ☒  
Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☐  
Waybill Attached: Yes ☐ No ☐  
Shipment Complete: Yes ☒ No ☐  
QC6 Inspection OK 07-05-25  
Work Order: \_\_\_\_\_

N/A ☒  
N/A ☒  
N/A ☒  
N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

*[Signature]*

Production/Admin:  
Date  
Received/Costing  
Initial

07/05/29  
RC 9713  
CS

Location \_\_\_\_\_

W:\FORMS\Purchasing\approved purch\RECREPORT Rev D

A) Regist :

Subtotal : 409.20  
Shipping : 25.00  
TVA : 0.00  
Total : 434.20

KAISER ALUMINUM  
MATERIAL CERTIFICATION

Dart's P.O. 3809

PAGE 1

KAISER ALUMINUM  
EXTRUDED PRODUCTS DIVISION  
3021 GORE ROAD  
LONDON ON N5V 5A9  
519-457-3610 FAX 519-457-3615

BL 722503

LES METAUX SPECIALISES SAMUE  
BAIE D' URFE  
SOLD TO

PQ H9X3T

N19458

PURCHASE ORDER

03/21/07

DATE PRINTED

V817102  
CUSTOMER PART NUMBER

BRD 1.000

DESCRIPTION

724691-001  
RELEASE-ITEM

C8737 091  
LOT

6061-T6511  
ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
C8737 091	0001 1	51.1	46.0	14.0	RE 96	N/A	N/A
C8737 091	0001 2	53.8	49.2	13.8	RE 96	N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
6061 LIMITS												
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	0.15

#commande 867140

#client 23577.5

\* item 3

APPLICABLE REQUIREMENTS:

ASTM-B221-05A-STENCILED  
ASME-SB221-1998 SECT II  
AMS-QQ-A-200/8 UNS#96061

(T6511 also conforms to T6-not applicable to other tempers)

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

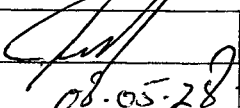
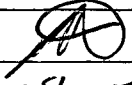

Bill Brennan  
Technical Manager

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39030
<b>Description:</b> Crosstube Assembly		<b>Part Number:</b> D3765-1
<b>Inspection Dwg:</b> D3765	<b>Rev:</b> A. Photo.	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	Ø.323	+0.006 -0.001	Ø.325	-			
	.500	+/-0.010	.503	-			
	1.750	+/-0.010	1.751	-			
	Ø.860	+0.008 -0.010	Ø.856	-			
	.219	+/-0.010	.217	-			
	R.063	+/-0.010	R.063	-			
	1.000	+/-0.010	1.004	-			
	1.250	+/-0.010	1.252	-			
	.050x45°	+/-0.010	.048x45°	-			
	.640	+/-0.010	.643	-			
SIDE B							

<b>Measured by:</b> 	<b>Audited by:</b> 	<b>Prototype Approval:</b> 
<b>Date:</b> 08.05.28	<b>Date:</b> 08.05.29	<b>Date:</b> 08.05.29

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	